

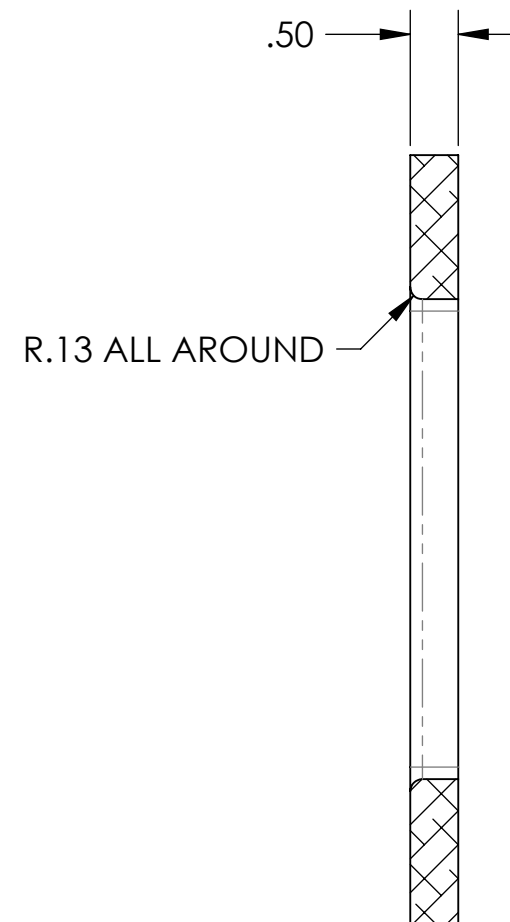
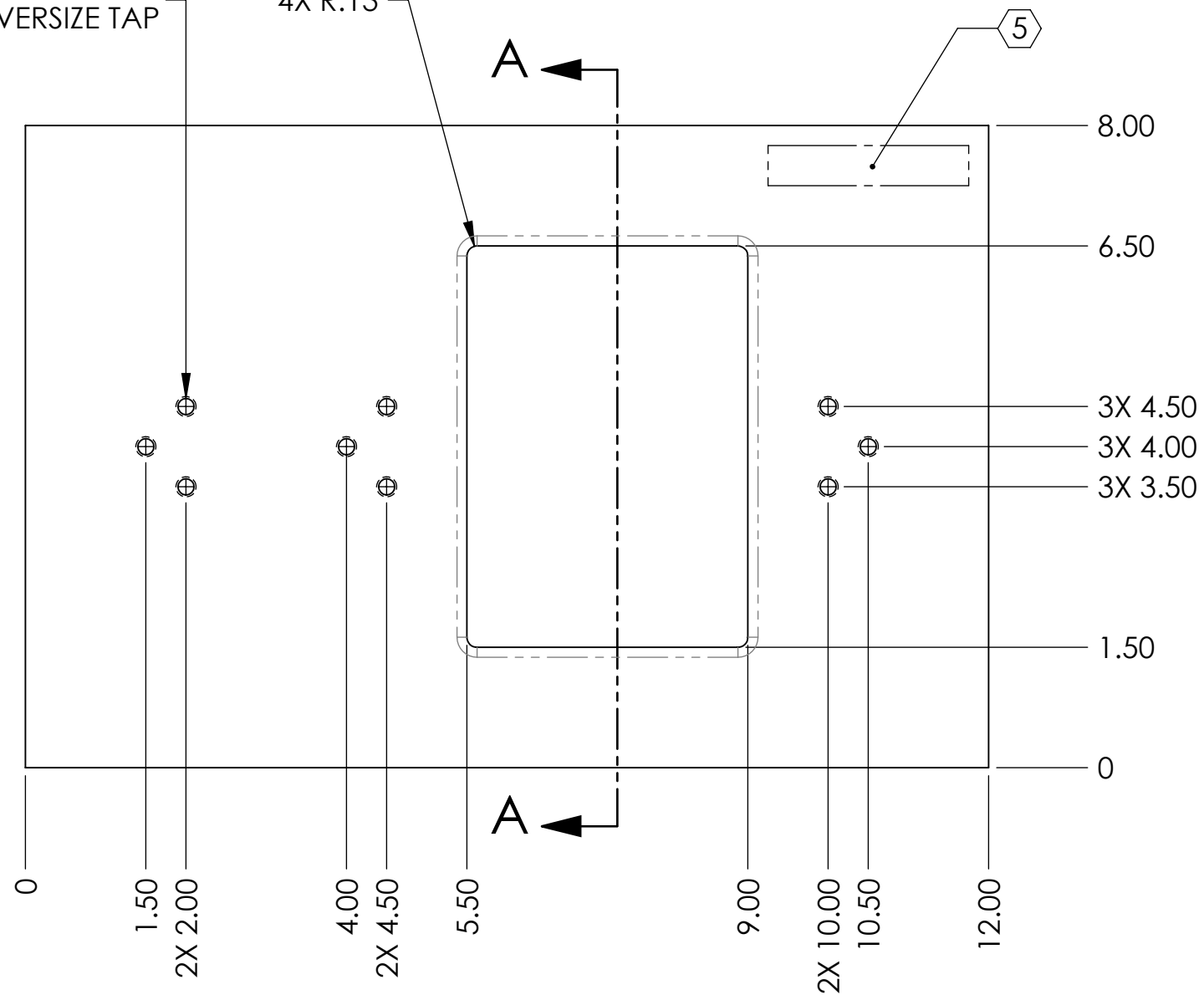
D0902460_Advanced_LIGO_SUS_HLTS_Base_Plate,_Sapphire_Prism_Placement_Fixture, PART PDM REV: V1-001, DRAWING PDM REV: V1-002

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	-
v2	02 SEP 2011	E1100826	-
-	-	-	-

9X 1/4-20 UNC THRU
 +.005 OVERSIZE TAP

4X R.13



SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, R.02 MIN.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL 6061-T6 Al FINISH 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS

NEXT ASSY OPTIC HOLDER, HAM TRIPLE SUS.

PART NAME			BASE PLATE		
DESIGNER	D. BRIDGES	09 SEP 2011	SIZE	DWG. NO. D0902460	
DRAFTER	D. BRIDGES	09 SEP 2011	REV.	v2	
CHECKER	B. MOORE	09 SEP 2011	SCALE	1:2	
APPROVAL			PROJECTION	SHEET 1 OF 1	